








Work Order ID 61751




Wednesday, September 01, 2010 1:25:09 PM

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BLUE

Item ID:	D2651-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Plug					
Start Date:	9/1/2010	Start Qty:	100.00		Cust Item ID:	
Required Date:	9/6/2010	Req'd Qty:	100.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>10-8-1</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2651	Rev B								
100	Hardinge CNC LATHE SMALL	0.00							
	Hardinge	Memo							
Hardinge CNC Lathe Small	1- Turn as per Folio FA219 and Dwg D2651□2- Deburr		SL	10/09/05		100			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	Memo							
Quality Control			SL	10/09/05		100			
120	QC8- Inspect parts - second check	0.00							
	QC	Memo							
Quality Control			DJP	10/09/06		100			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start

Revision ID:

Stop

Item Name: Plug

Start Date: 9/1/2010 Start Qty: 100.00

Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 100.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Small Fab

Small Fab

0.00

Memo

0.00

Deburrias per dwg D2651

Tumble

810-8-8

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

BR 10-9-9

100

155



SprayPaint

Spray Painting per QSI005 4.2

0.00

Memo

0.00

PRIME : B 114424
PAINT DELFEET BLUE : B 115509
CLEAR DELFLEET : B 115506

ml 10 09 24 ①

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Stop

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Cust Item ID:

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Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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165

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

RET 10-09-27 (100)

170

Identify as per dwg & Stock Location: FP-A

0.00



Packaging

Memo

0.00

Packaging

= 3M 10/09/27

x 100

/

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/27

C 2 10/9/27

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Picklist Print

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Work Order ID: 61751



Parent Item: D2651-1



Parent Item Name: Plug

Start Date: 9/1/2010

Required Date: 9/6/2010

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: A ☐ 02.04.15 ☐ New Issue ☐ NG ☐
IPP: B ☐ 05.12.12 ☐ added deburr EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500 		Purchased		No		100	f	38.8700	0.0401	4.221053			

6061-T6 Round Bar .500"

Location

Loc Qty

Loc Code

MAT

38.87

114488

38.87

43

2L 10/09/05

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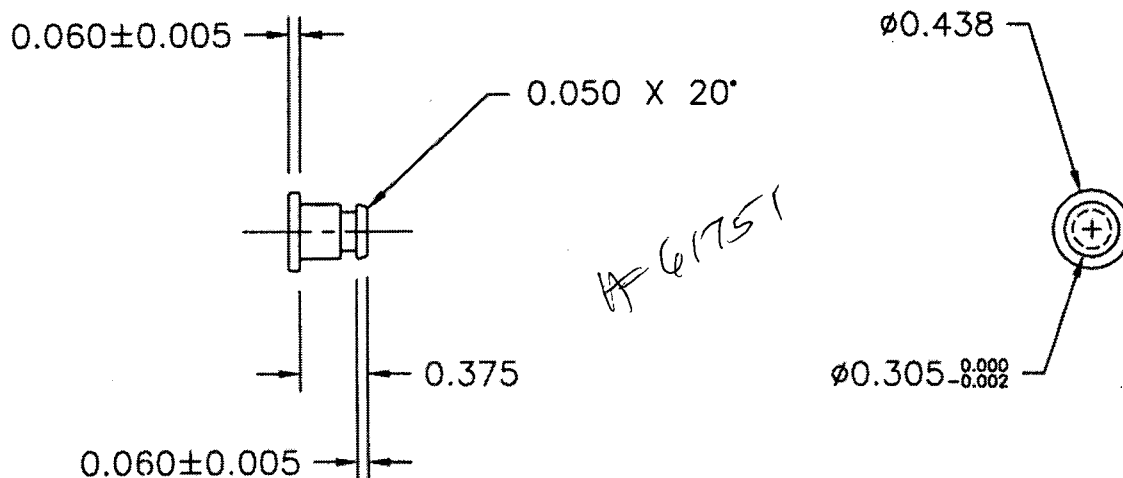
NOTE: Date & initial all entries



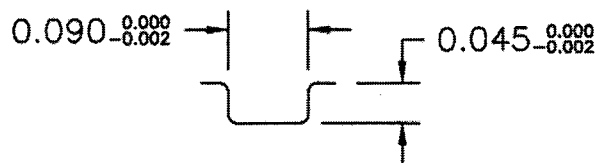
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED
03.12.19 #

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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